

Date: Tuesday, 8/7/2007 5:33:30 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 33838		
Estimate Number	: 10765		
P.O. Number	: <i>NA</i>	Part Number	: D32451
This Issue	: 8/7/2007	Drawing Number	: D3245 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i>	Drawing Revision	: A
Previous Run	: 23889	Material	: <i>NA</i>
Written By	: <i>SLM/07.08.07</i>	Due Date	: 8/14/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est. A 04.07.07 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S22GA	304/316 .032 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8442 sf(s)/Unit Total: 0.8442 sf(s)

304/316 .032 Sheet

Batch: *M105061**SAD 07/08/07*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

\*\*\*\*prog.D3245-1/-2\*\*\*\*

*(No Holes)*Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*SAD 07/08/07*

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/08/07*

②

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*SLM/07.08.07*

③

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

C'sink as per Dwg D3245

*MF 07-08-09.*

Form D3245-1 as per Dwg D3245 Identify as D3245-1

*SB 07/08/08*

④

Date: Tuesday, 8/7/2007 5:33:30 PM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 33838

Part Number: D32451

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/09 + (1.041)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *ST*

*Jul/07-08-10*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/08/10*

Job Completion

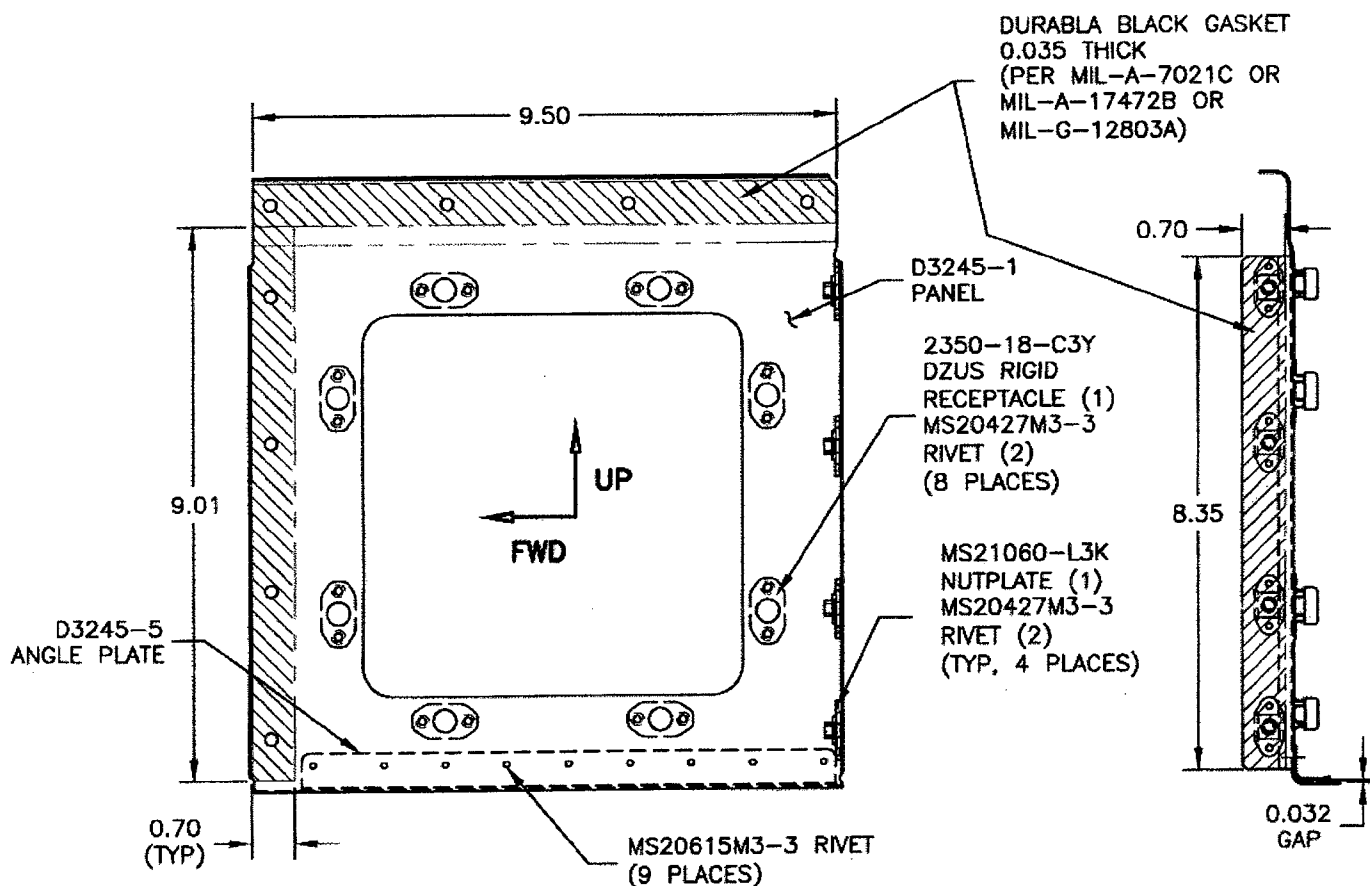


*Jul/07-08-10*



DESIGN	RF	DRAWN BY	P	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
				D3245	SHEET 1 OF 6
DATE	04.01.27	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:3
A	04.01.27	NEW ISSUE			

RELEASED  
04.04.21 #



### D3245-041 ACCESS PANEL ASSEMBLY

#### D3245-041 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

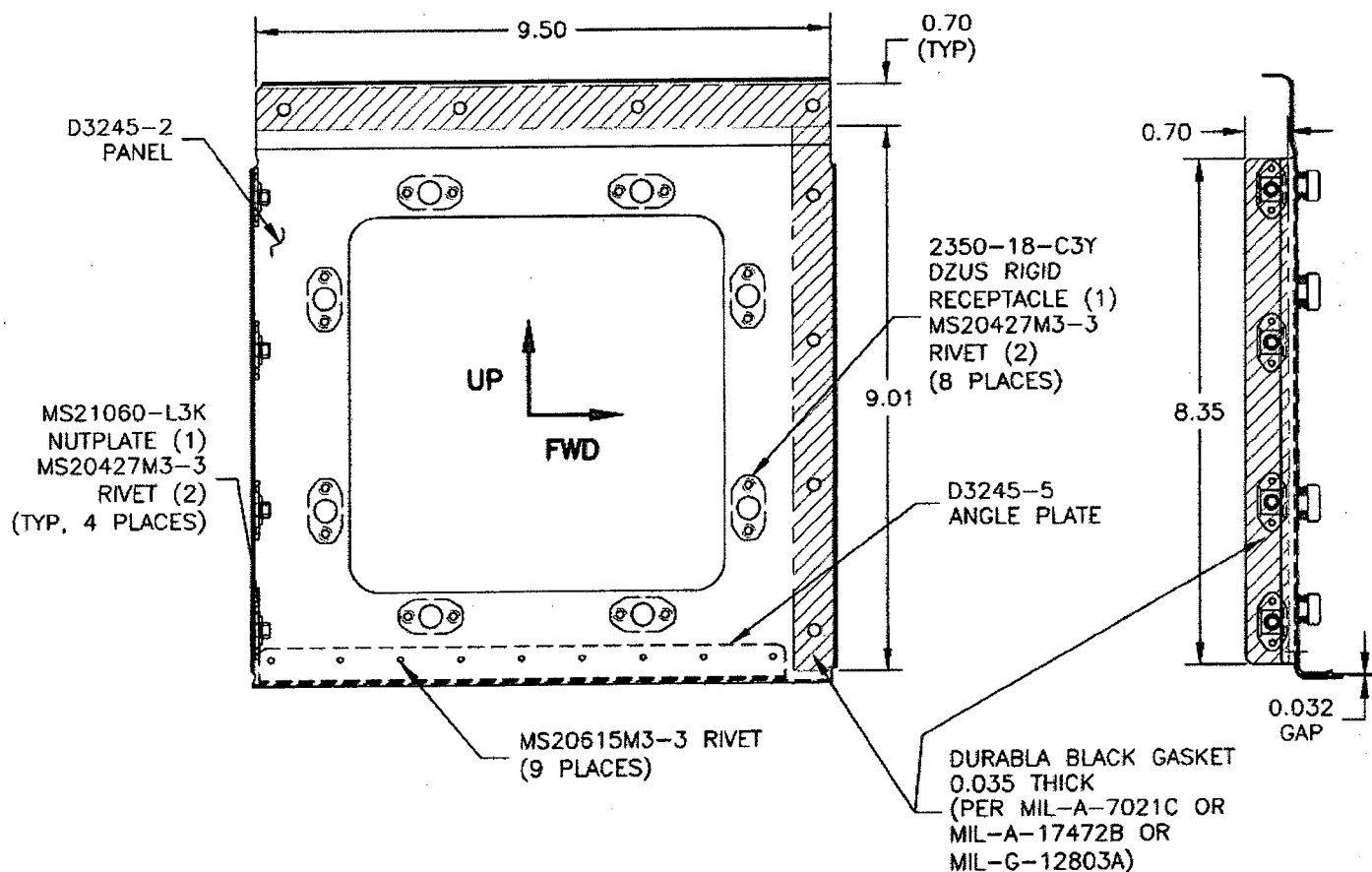
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CHECKED A	APPROVED A	DRAWING NO. D3245	REV. A SHEET 2 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY SCALE 1:3	

RELEASED  
04/04/21



**D3245-042 ACCESS PANEL ASSEMBLY**

D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE  
IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

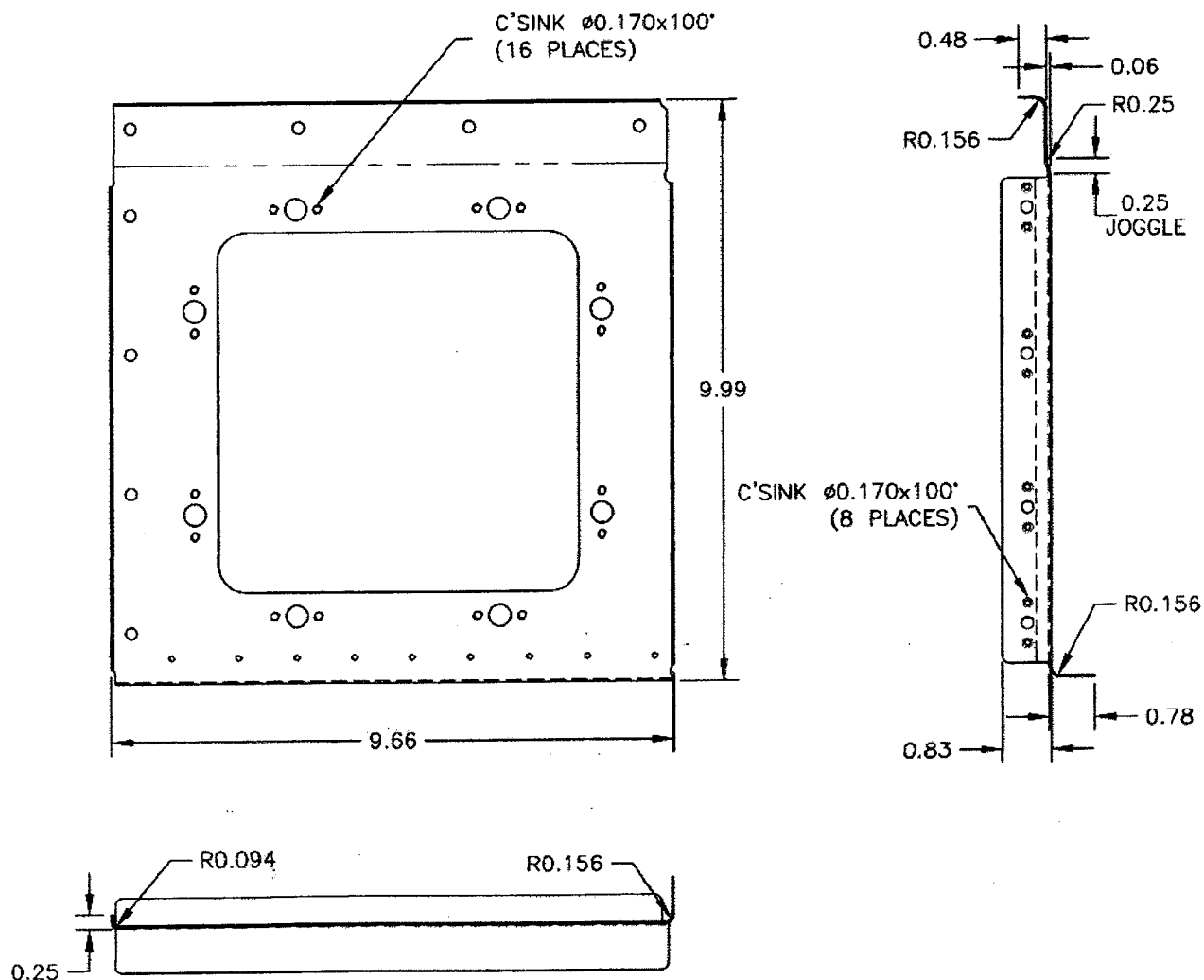
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3245	REV. A SHEET 3 OF 6
DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3

RELEASED  
04.04.21



D3245-1 PANEL BEND DETAIL SHOWN  
BEND D3245-2 PANEL OPPOSITE

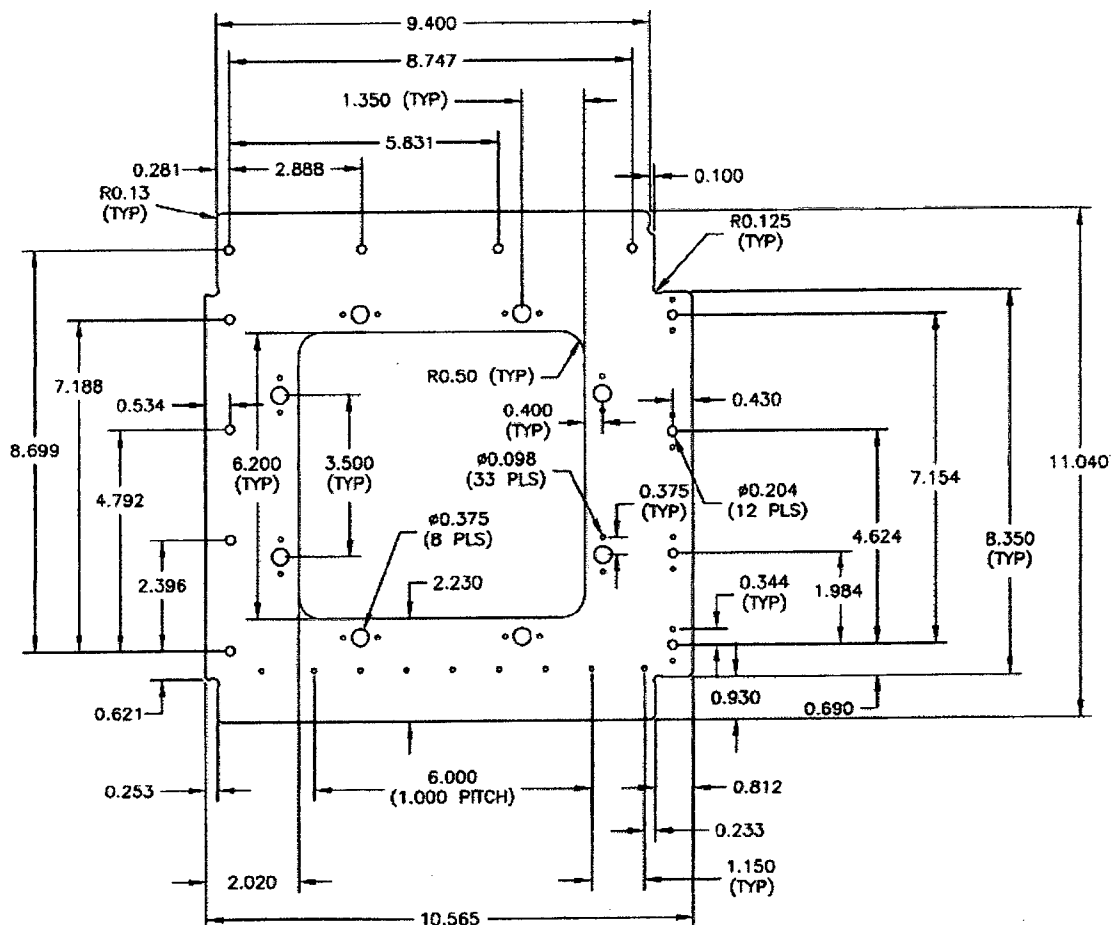
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CHECKED H	APPROVED H	DRAWING NO. D3245	REV. A SHEET 4 OF 6
DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED  
04.04.21 H



### D3245-1/-2 PANEL FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

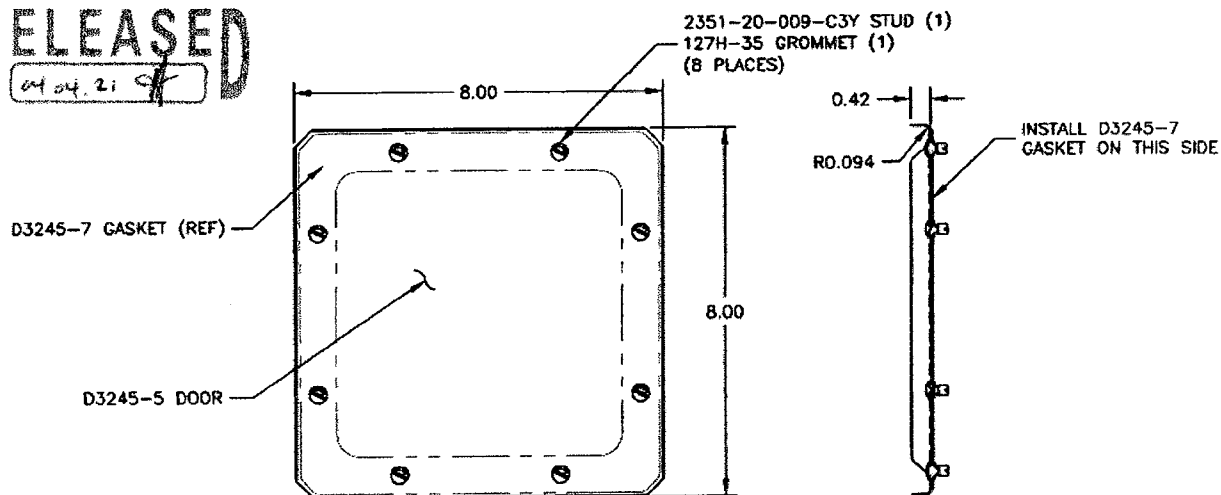
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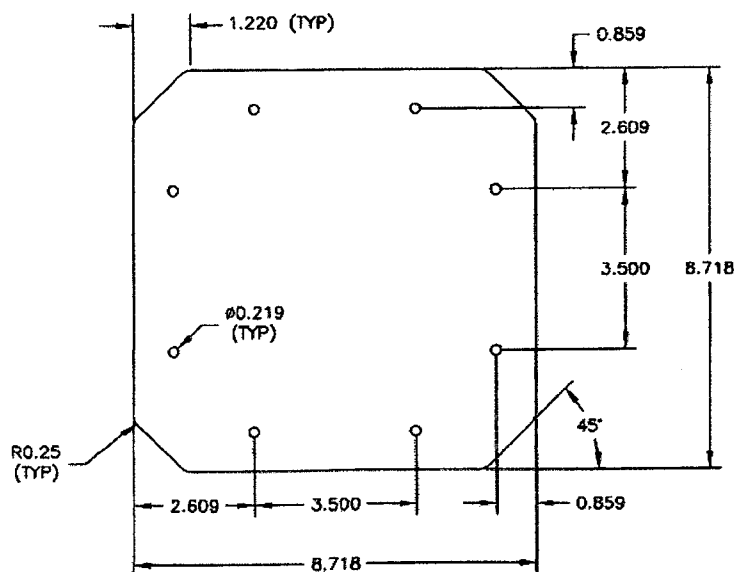


DESIGN RF	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3245	REV. A SHEET 5 OF 6
DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED  
04.04.21

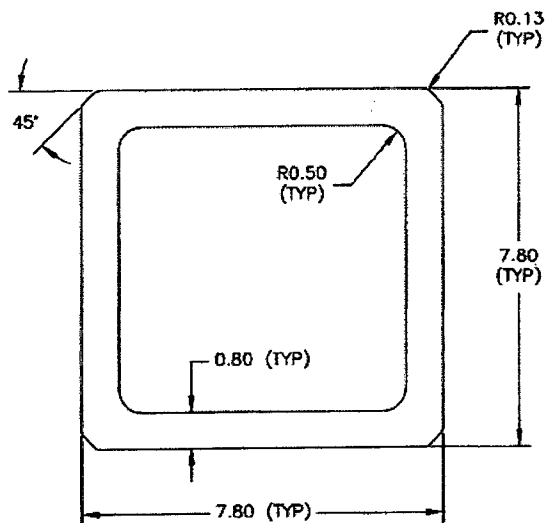


**D3245-043 DOOR ASSEMBLY**



**D3245-3 DOOR FLAT PATTERN**

MATERIAL: AISI 304/316 SS 0.032 THICK  
ANNEALED (REF. M304S22GA)



**D3245-7 GASKET**

MATERIAL: DURABLE BLACK GASKET 0.035 THICK  
(PER. MIL-A-7021C OR MIL-A-17472B  
OR MIL-G-12803A)

**D3245-043 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE  
IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

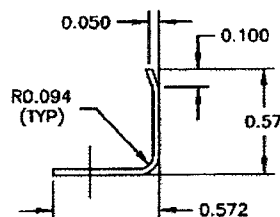
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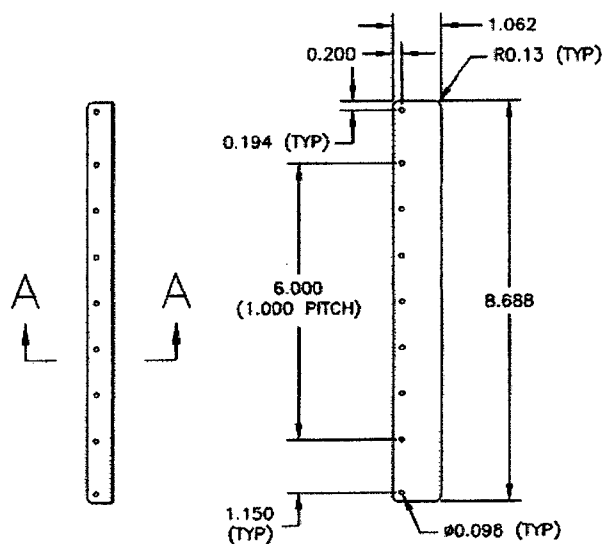


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3245	REV. A SHEET 6 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05



**D3245-5 BEND DETAIL**  
**VIEW A-A**  
**SCALE 1:1**



**D3245-5 FLAT PATTERN**

**D3245-5 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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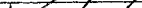


DART AEROSPACE LTD		Work Order:	33839
Description: Panel		Part Number:	032452
Inspection Dwg: 03245	Rev: A	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. <b>Introduction</b></p> <p>The purpose of this document is to provide a detailed description of the product and its features. This document is intended for use by the marketing and sales departments.</p> <p>2. <b>Product Description</b></p> <p>The product is a high-quality, durable, and reliable. It is designed to meet the needs of the market and provide a superior user experience.</p> <p>3. <b>Features and Benefits</b></p> <p>The product features a range of benefits, including its durability, reliability, and performance. It is designed to be easy to use and maintain, and it offers a range of features that are not available in other products.</p> <p>4. <b>Conclusion</b></p> <p>The product is a high-quality, durable, and reliable. It is designed to meet the needs of the market and provide a superior user experience. It is a product that is worth the investment and is a great addition to the product line.</p>	<p>1. <b>Introduction</b></p> <p>The purpose of this document is to provide a detailed description of the product and its features. This document is intended for use by the marketing and sales departments.</p> <p>2. <b>Product Description</b></p> <p>The product is a high-quality, durable, and reliable. It is designed to meet the needs of the market and provide a superior user experience.</p> <p>3. <b>Features and Benefits</b></p> <p>The product features a range of benefits, including its durability, reliability, and performance. It is designed to be easy to use and maintain, and it offers a range of features that are not available in other products.</p> <p>4. <b>Conclusion</b></p> <p>The product is a high-quality, durable, and reliable. It is designed to meet the needs of the market and provide a superior user experience. It is a product that is worth the investment and is a great addition to the product line.</p>

[illegible]

Measured by:	SAD	Audited by:		Prototype Approval:	N/A
Date:	07/08/08	Date:	07.08.08	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

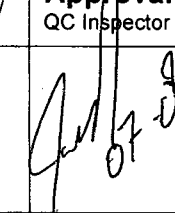
☒ First Article    ☐ Prototype

[illegible]

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/09	6.1	8 2350-18C3E	Batch <u>M19688</u>	mf	07-08-09	1		
		16 MS 20427 M3-3	Batch <u>M101840</u>					
		9 MS 20615 M3-3	Batch <u>M17654</u>					
		1 D 3245-5	Batch <u>B33837</u>					
		Durable Black	Gasket Batch <u>B23711</u>					
		1 .70 x 8.35						
		1 .70 x 9.50						
		1 .70 x 9.01						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries